

Date: Tuesday, 09/12/2008 9:38:58 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HAT BIN 206 A/B W/LITTER
Job Number : 43952	
Estimate Number : 13690	
P.O. Number :	
This Issue : 09/12/2008 S.O. No. :	Part Number : D38243
Prsht Rev. : NC	Drawing Number : D3824-3
First Issue : / / Type : R&D THERMOFORMING	Project Number : IN0002
Previous Run :	Drawing Revision : PROTOTYPE
Written By :	Material :
Checked & Approved By : <u>JUD 08.12.09</u>	Due Date : 12/12/2008 Qty: 1 Um: Each
Comment : Est. Rev. A 08/123/08 New Issue DL	

Additional Product

Job Number:



PROTOTYPE
 09.12.08
 UPDATED 08.12.22

Seq. #:	Machine Or Operation:	Description :	PER TEST 06.12.16
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1.0	MKYD6185S080P362015	6185 KYDEX .080"
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MATERIAL CERTIFICATION
REQ'D UPON DELIVERY



Comment: Qty.: 11.3747 sf(s)/Unit Total: 11.3747 sf(s)
 6185 Kydex .080"

M 109703

08.10.08

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Machine set up

M 08.12.08

3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

(X1)
 08.12.10
 LK 08.12.10

4.0	THERMOFORMING	THERMOFORMING MACHINE
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**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D3824-3 and folio (FTA 9448 Prototype) using tool DT 9448

Dwg. Rev. A - PROTOTYPE
 Folio Rev. A

(X1)
 08.12.10
 LK 08.12.10

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

(X1)
 08.12.10
 LK 08.12.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 09/12/2008 9:38:58 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HAT BIN 206 A/B W/LITTER

Job Number: 43952

Part Number: D38243

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

BB 08/11/12 (X1)

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 08/17/12 (21)

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06.12.12 (1)

Check dimensions to ensure conformity to drawing tolerances.

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PT 01.12.12

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FOR ENGINEERING USE ONLY

NOT FOR STOCK
PT 06.12.22

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.12.15 Prototype

with DEVIATIONS
PER FAX attached

Job Completion



W 08.12.24

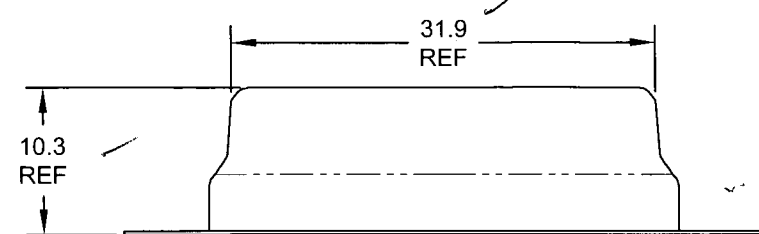
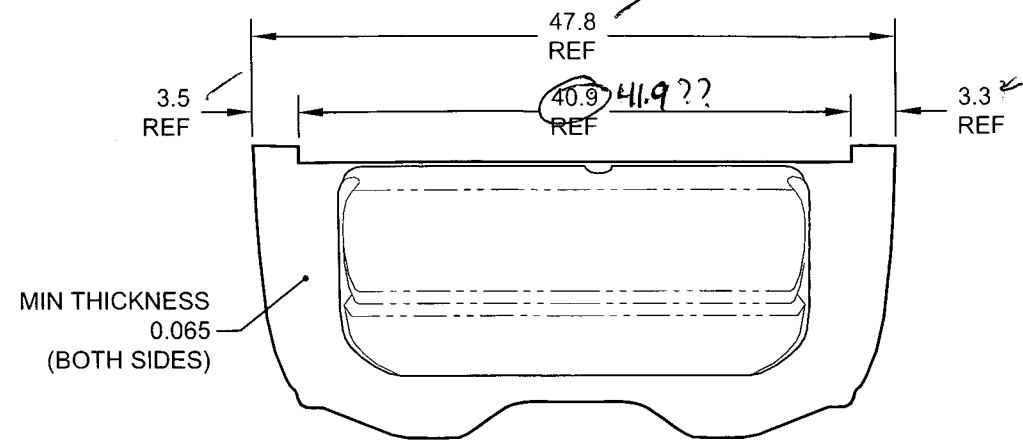
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

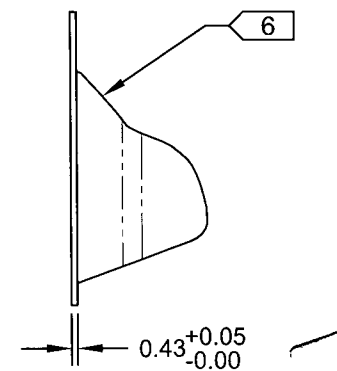
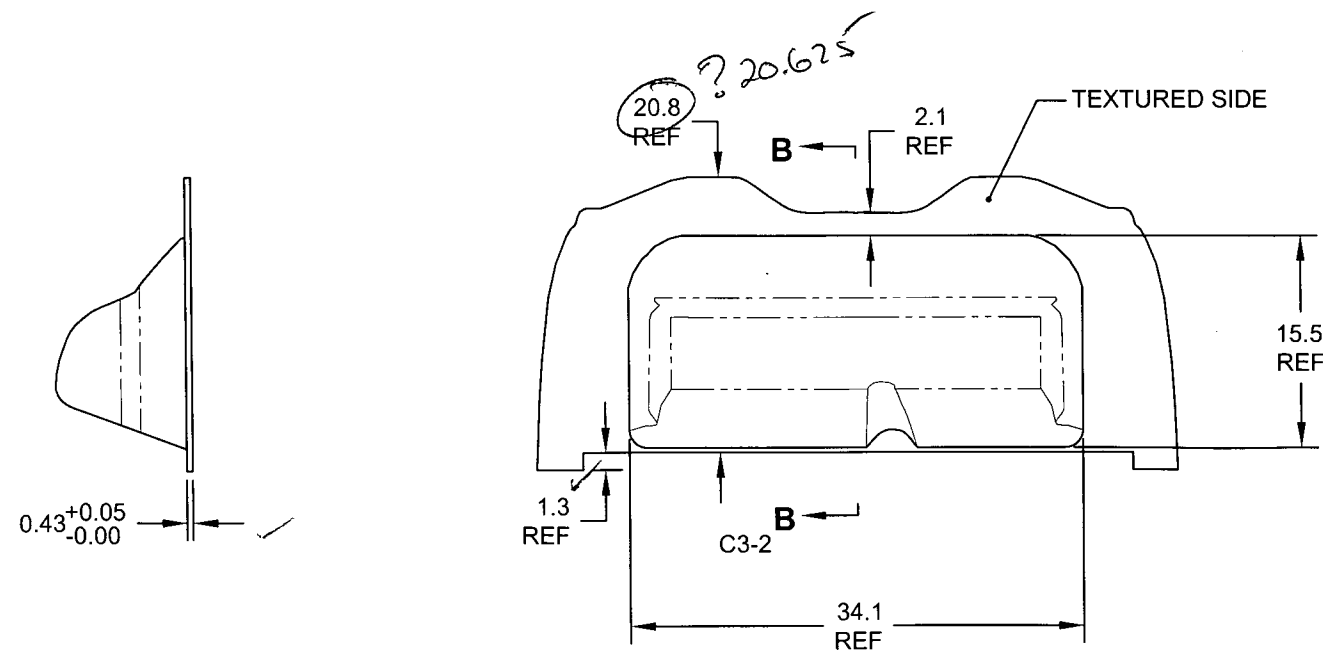
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SECTION B-B
SCALE 2X



D3824-3 HAT BIN

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
(REF DART SPEC MKYD6185S.080-P3-62015)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3824-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 4.1 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9448 PER DART QSI 022

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
08.12.07 *PT*

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3824	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		HAT BIN	NTS
DATE	08.10.01	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

DART AEROSPACE LTD		Work Order:	43952
Description: <i>Not Bld / Prototype</i> ^{with Litter}		Part Number:	D3824-3
Inspection Dwg: D3824 Rev: A		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"				
Shape Definition		✓		
Texture Retention		✓		
Material imperfections such as bumps, cracks, voids, scratching		✓		Huge ugly spots on the inside

Measured by: *[Signature]*

Date: 08-12-12

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.5 (Ref)	± 0.100	3.487	✓			
3.3 (Ref)	"	3.24	✓			
47.8 (Ref)	"	47.8125	✓			
40.9 (Ref)	"	41.125				update on dwg.
0.065	min.	0.050	0.055	0.0512		too thick @ 0.080 min.
10.3 (Ref)	± 0.100	10.3	✓			
31.9 (Ref)	± 0.100	31.9	✓			
2.1 (Ref)	± 0.100	2.025	✓			
20.8 (Ref)	± 0.100	20.625		✓		Review dim
15.5 (Ref)	± 0.100	15.5	✓			
1.3 (Ref)	± 0.100	1.25	✓			
34.1 (Ref)	± 0.100	34.1875	✓			

Measured by: *[Signature]*

Date: 08-12-12

Audited by: *[Signature]*

Date: 08-12-12

Prototype Approval: *[Signature]*

Date: 08-12-12

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

Receiving Report

Date: _____

Batch No:

Supplier:

Dart P/O:

Packing Slip:

Yes

No

Release Note Attached:

Yes

~~No~~

N/A

Invoice:

Yes

No

Waybill Attached:

Yes

No

N/A

Receipt:

Cash

Cr

Shipment Complete

Yes

No

N/A

QC6 Inspection Work Order

N/A

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

Admin:

Location

30

سابك
sabic

SABIC Polymershapes

250 OLD INNES RD. 519 OTTAWA, ONT. K1B 5L3
TEL: 613 745 7043 FAX: 613 745 8163

CERTIFICATE OF COMPLIANCE

SOLD TO: DART AEROSPACE

DATE: 10/3/2008

YOUR PURCHASE ORDER : 7280

OUR SHIPPER NO: 084287

LINE ITEM # : 1

QUANTITY: 51

54 804287

08/01/27

DESCRIPTION: .080 x 48 x 96 Kydex 6185-P3 IVORY 62015.

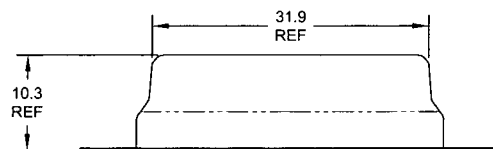
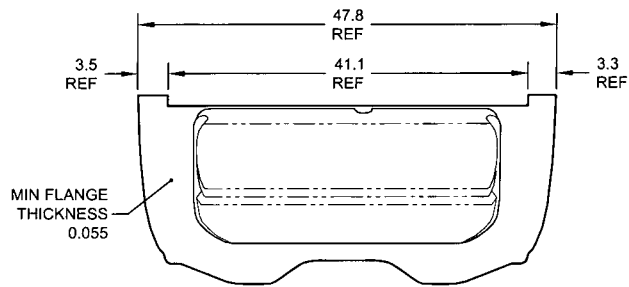
THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH: FAR 25.853 (a)

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS OF THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE PROCUREMENT SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND LATEST REVISIONS AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

AUTHORIZED REPRESENTATIVE SIGNATURE

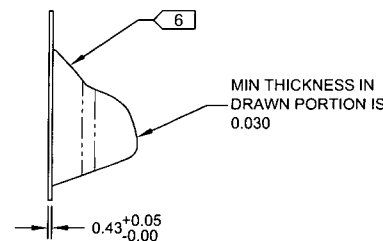
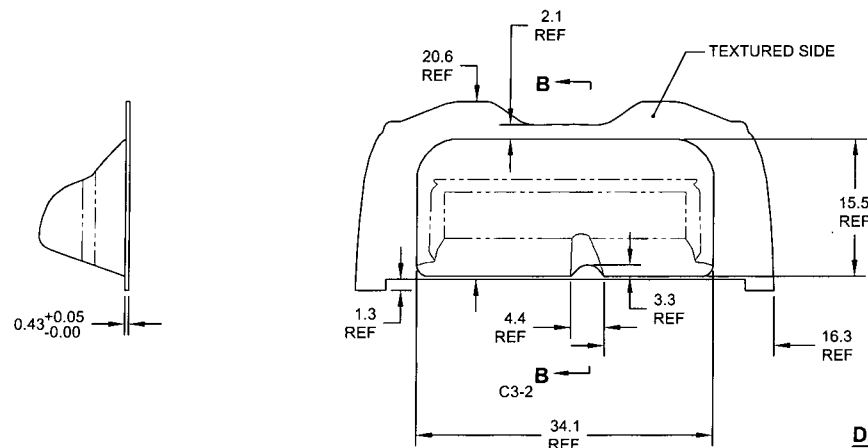
Jon Caldwell

JON CALDWELL
BRANCH MANAGER



SECTION B-B
SCALE 2X

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
08.12.22 *dy*
REVISED FROM 08.12.08 *pwg*
TO INCLUDE DIMENSION
PER FAI SHEET



D3824-3 HAT BIN
(BELL 206 A/B, LITTER KIT COMPATIBLE)

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING

- NOTES:**
- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
(REF DART SPEC MKYD6185S.080-P3-62015)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3824-3" USING VIBRATING STYLUS
 - 7) WEIGHT: 3.7 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT9448 PER DART QSI 022. TRIM PER MOLD

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3824	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		HAT BIN (BELL 206 A/B)	NTS
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